

# Work Order ID 85667

**\*85667\***

Page 1

June-13-12 1:00:07 PM

Item ID: D4277-7

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib

Start Date: 13/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4277

D

100

0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4277  
2- Remove marking,debur

(4)

SAD 12.09.09

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

QC

Memo

0.00

Quality Control

DAS  
24  
9-09

12.10.9

4

120

Identify as per dwg & Stock Location: WA

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN BASKET CELL\*\*\*

DAS  
24  
9-09

12.10.9

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85667****\*85667\***

Page 2

June-13-12 1:00:07 PM

Item ID: D4277-7

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib

Start Date: 13/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/10/11 *[Signature]*  
WME  
12-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-13-12 1:00:12 PM

Page 1

Work Order ID: 85667

\*85667\*

Parent Item: D4277-7

\*D4277-7\*

Parent Item Name: Rib

Start Date: 13/06/2012

Required Date: 20/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased		No		100	f	787.0237	0.1442	0.607158			

\*M304TS0 500W 049\*  
Square Tubing

\*\*

SAD 12-09-24

Location

Loc Qty

Loc Code

MAT034

787.0236723

118460

0.00001534

121328

2.970794

121565

198.052863

121808

586

21122413

0.6072

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D4277-1 RIB

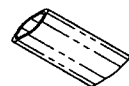
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85667 MLJ  
12/06/13

D4277-3 RIB

D4277-5 RIB

C

C



D4277-7 RIB

D4277-9 RIB

B

B

D4277-11 RIB

RELEASED  
2011-02-24  
WJ

A

A

D4277-19 RIB



D	CHANGED ANGLE FROM 71° TO 81° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV - 13/-15/-17 (OBSOLETE); -3: 8.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2), -5: 24.25 WAS 20.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIBS	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

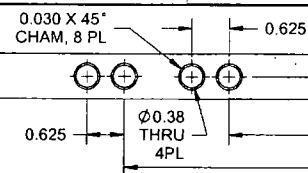
1

D

C

B

A



25667

25.00

23.50  
REF**D4277-1 RIB**

6.09

**D4277-3 RIB**

24.25

**D4277-5 RIB**1.73  
REF

1.47

1.38  
REF0.50  
REF0.049  
REF**D4277-7 RIB**

13.50

**D4277-9 RIB**0.049  
REF0.50  
REF0.049  
REF0.50  
REFRELEASED  
2011-02-24

## NOTES:

## 1) MATERIAL.

-1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

## 2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4277</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIBS</b>	NTS
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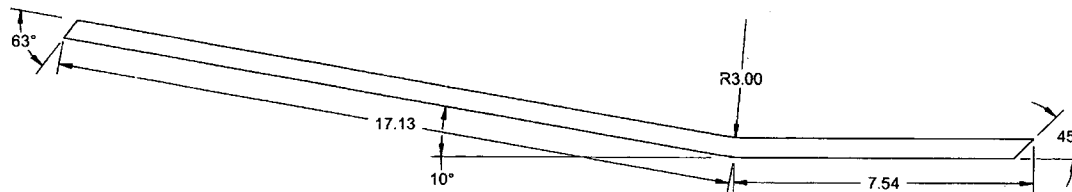
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

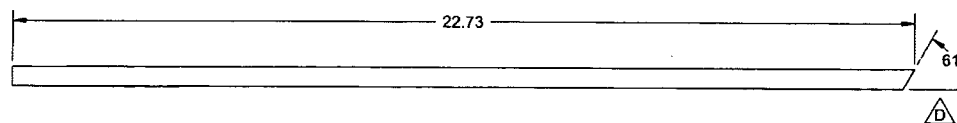
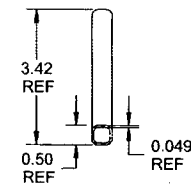
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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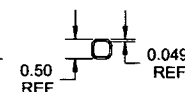
**NOTE:** Date & initial all entries



**D4277-11 RIB**



**D4277-19 RIB**



**NOTES:**

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4277</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIBS</b>	NTS
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**RELEASED**  
2011-02-24

*85667*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries